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D5336-041
Job Sheet 180059



Part No: D5336-041

Job Qty: 1 ea

Part Name: Basket Lid Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/28/18

Job Tracking No:

Due Date: 7/13/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEETS 1,2,3,7 IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM IPP REV:B 17.03.27 AS PER REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/13/18	7/13/18	0.00	0.00	Start Up Large Fab-6		
100	Large Fab	1 pcs	7/13/18	7/13/18	0.00	8.02	Large Fab 1		
110	QC	1 pcs	7/13/18	7/13/18	0.00	0.00	QC9		
120	QC	1 pcs	7/13/18	7/13/18	0.00	0.00	QC5		
130	Powdercoat	1 pcs	7/13/18	7/13/18	0.00	0.11	Powdercoat4		
140	HandFinish	1 pcs	7/13/18	7/13/18	0.00	0.75	HandFinish3		
150	QC	1 pcs	7/13/18	7/13/18	0.00	0.00	QC3		
160	Packaging	1 pcs	7/13/18	7/13/18	0.00	0.00	Packaging3-2		
170	QC21-SA	1 Ea	7/13/18	7/13/18	0.00	0.00	QC21		

Part Op 100 - 1- Assemble ribs , weld as per dwg D5336 using DT10196 2- Weld hinge (3) and Mounting brackets as per dwg
Descriptions: D5336 ***inspect before welding mesh*** 3- Cut mesh as per dwg D5334-1 4- Tack weld mesh on basket as per dwg
D5336 ***Make sure to place mesh correctly on lid, check with label plate before tacking mesh***
130 - *** Mask holes and sides of hinge prior to powdercoat*** Start Time: 16:30 Oven Temperature: 320°F
Finish Time: 11:00 PM
140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5072780
D4016-3	Hinge Half, Lid	3 Ea (3 ea)	90-Start up Operation	5073266
D5332-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	50064596
D5332-1	Rib	2 Ea (2 ea)	90-Start up Operation	5042727
D5332-13	Rib	3 Ea (3 ea)	90-Start up Operation	50897672 5042732
D5332-15	Rib	2 Ea (2 ea)	90-Start up Operation	5064736
D5332-19	Rib	2 Ea (2 ea)	90-Start up Operation	5064693
D5335-1	Data Plate	1 Ea (1 ea)	90-Start up Operation	50642618 58840
M304EX0.75-16F	Expanded Metal Flat SS	8.1600 sf (8.16 ea)	90-Start up Operation	5046611

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	53	0
	D4016-3	3	40	0
	D5332-041	2	2	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

D5332-1	2	2	0
D5332-13	3	2	0
D5332-15	2	3	0
D5332-19	2	2	0
D5335-1	1	6	0
M304EX0.75-16F	8	903	0

Part Specifications

Specifications could not be found.

Plex 6/28/18 9:56 AM Dart.lajeunesse.marie

